

Date: Tuesday, 30/09/2008 8:54:19 AM
User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	STEP SPACER
Job Number :	42344B		
Estimate Number :	10378		
P.O. Number :		Part Number :	D30653
This Issue :	30/09/2008	Drawing Number :	D3065 REV. B
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	//	Drawing Revision :	B
Previous Run :	41445B	Material :	
Written By :		Due Date :	15/10/2008
Checked & Approved By :	<u>JULIE LECOQ</u>	Qty:	100 50
Comment :	Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF Est Rev:D Now on Water Jet 06-04-11 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.2287 sf(s)/Unit Total : 11.4345 sf(s)
Material: 2024-T3 (QQ-A-250/4) 0.040" thick
(M2024T3S.040) Batch: 107461 IB 8-10-24

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D
Dwg Rev: B IB 8-10-24
Prog Rev: B
2-Deburr if necessary IB 8-10-24

(54)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

counters
5 08/10/24 (54)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr Stack

u/a Soshulz4
Done at step #22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 30/09/2008 8:54:19 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 42344B

Part Number: D30653

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
Bend as per Dwg D3065

SB 08/10/28

(54)

7.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 08/10/29 counter (54)

8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

ll 08-10-30

(54)

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT CHEMICAL CONVERSION COAT

61 Fx 08/10/

10.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

5xL wire P 08/10/30 (54)

11.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/10/31

Job Completion



MF 08-10-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 42344B
Description: Step Spacer		Part Number: D3065-3
Inspection Dwg: D3065	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.260	+/-0.010	1.258	*			
3.260	+/-0.010	3.260	*			
5.260	+/-0.010	5.263	*			
6.520	+/-0.010	6.521	*			
2.093	+/-0.010	2.090	*			
3.936	+/-0.010	3.937	*			
4.186	+/-0.010	4.184	*			
Ø0.128	+0.005/-0.000	.133	*			
Ø1.250	+0.005/-0.000	1.254	*			
Pitch 1.204	+/-0.005	1.205	*			
0.040	+/-0.010	.041	*			

Measured by: PB	Audited by: S	Prototype Approval:	N/A
Date: 8-10-24	Date: 08/10/24	Date:	N/A

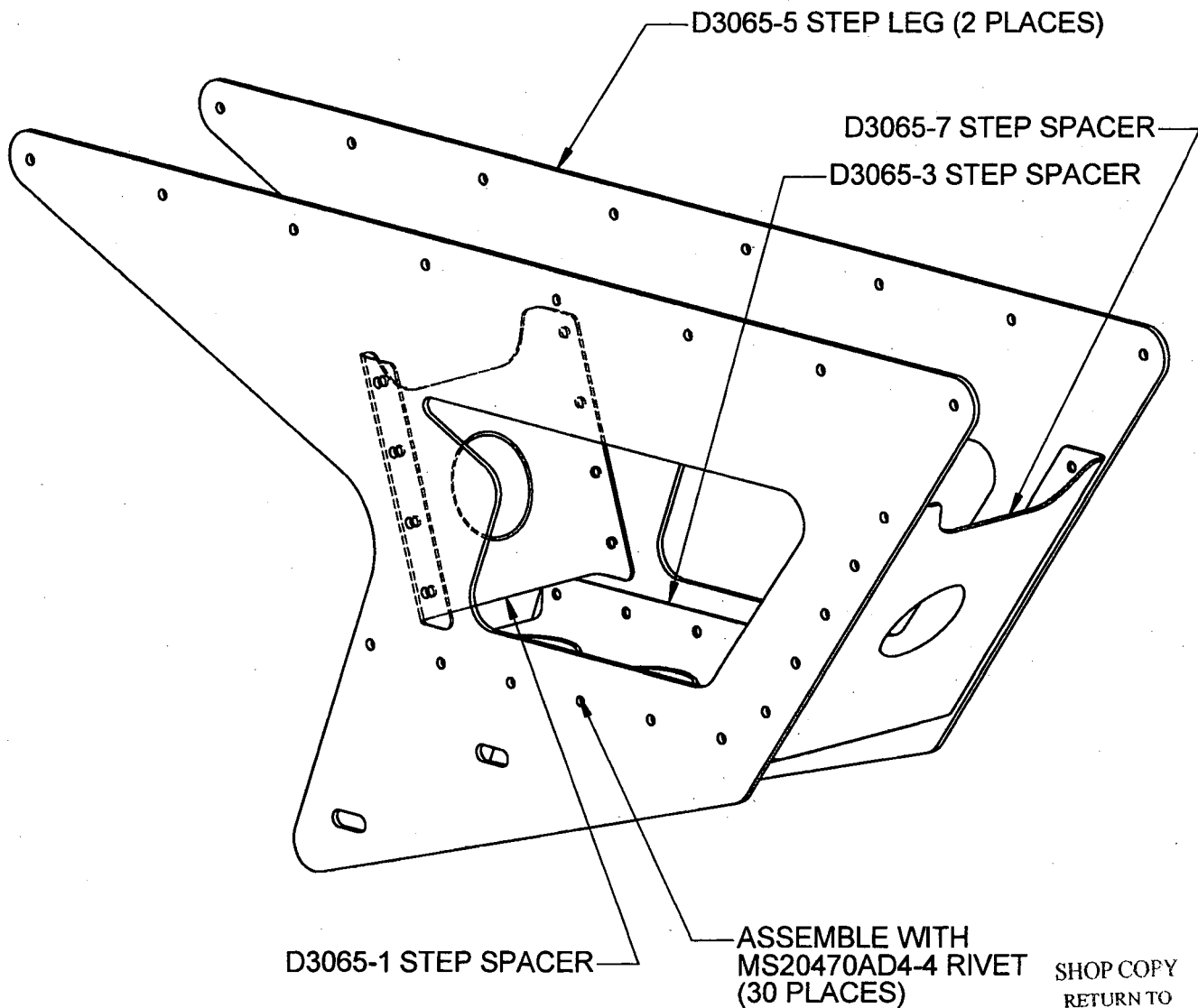
Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue P/O D3065-041	KJ/RF	
B	04.08.12	Removed dimension 1.204	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	
D	07.09.06	0.040 dimension added	KJ/JLM	BE

DART

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*



D3065-041 STEP LEG ASSEMBLY

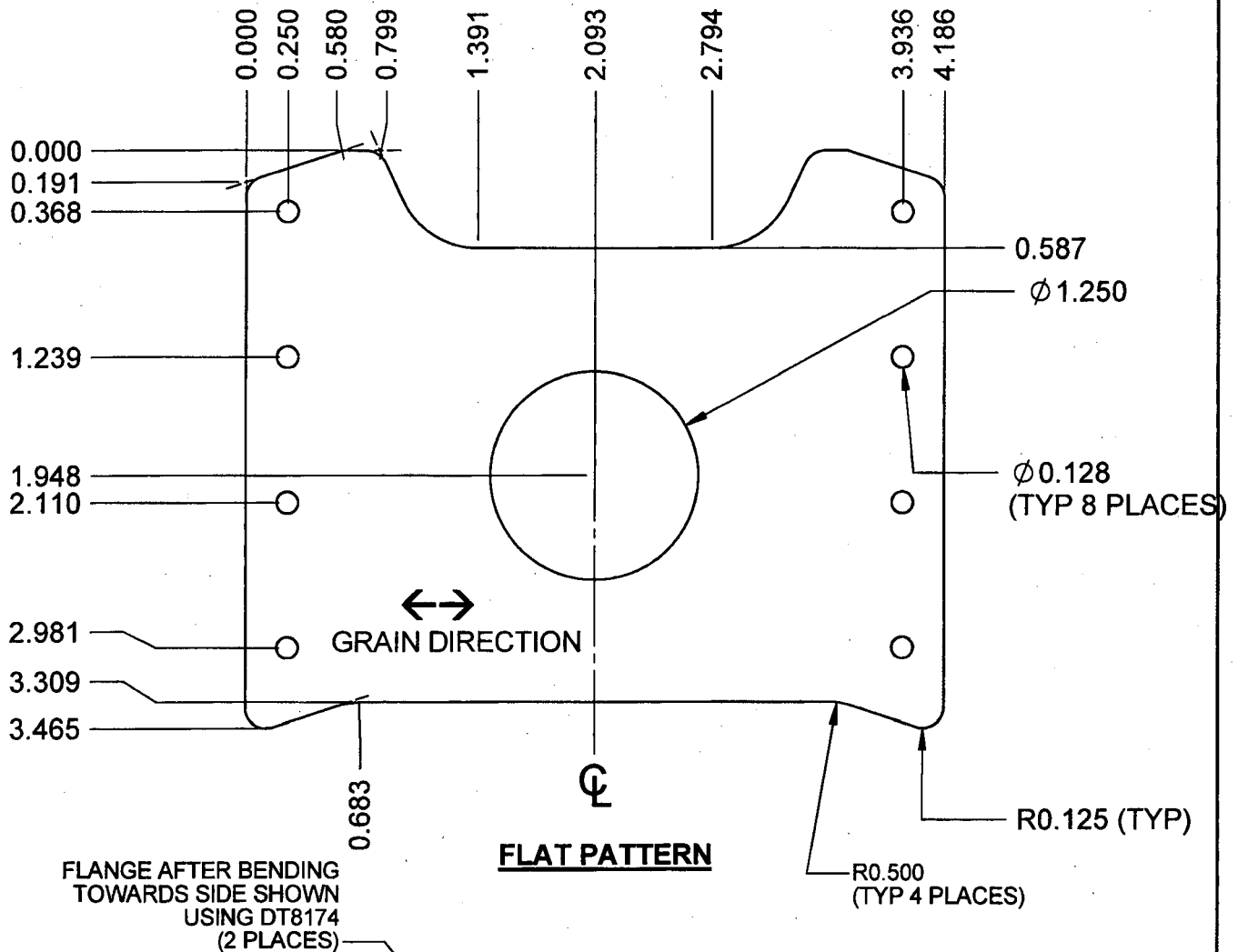
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DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**D3065-1 STEP SPACER****BEND DETAIL**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

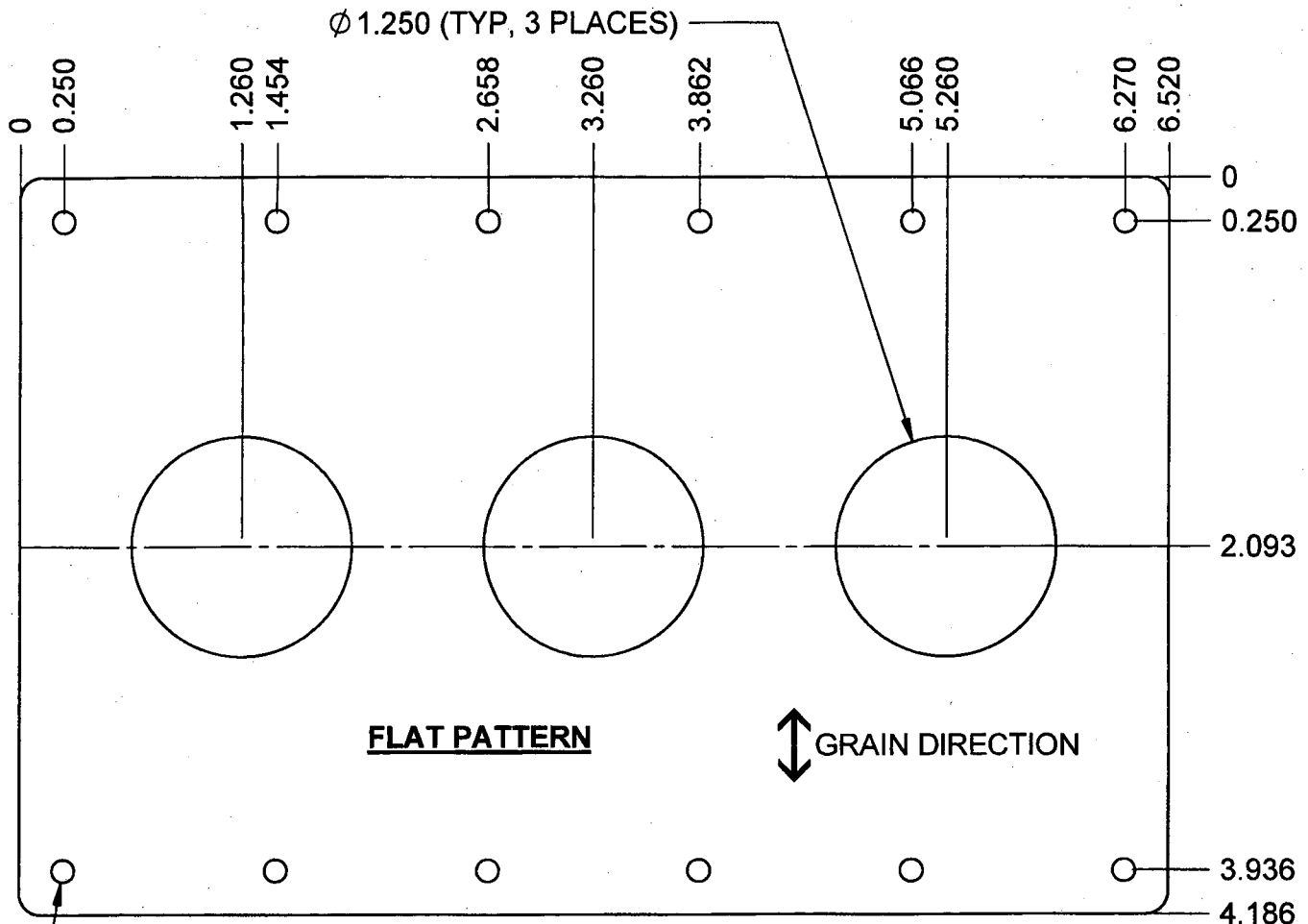
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DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

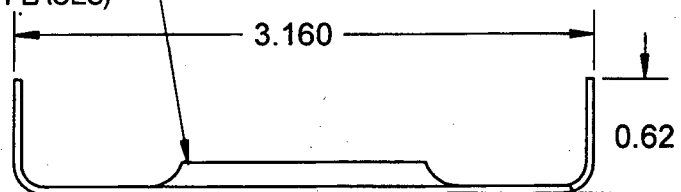


FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

RELEASED

06.06.20 *[Signature]*



BEND DETAIL

D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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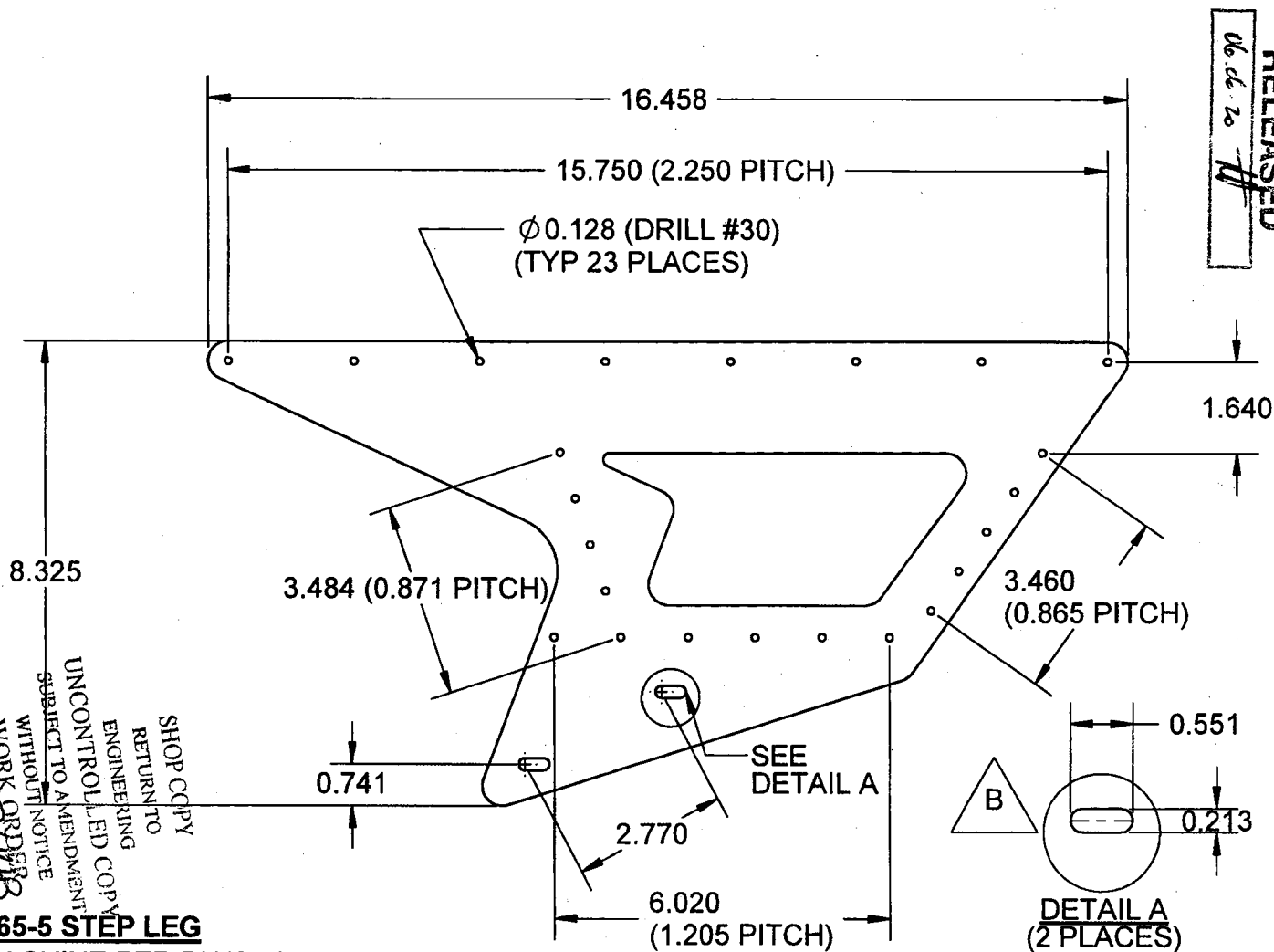
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				HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>PH</i>	APPROVED	<i>PH</i>	DRAWING NO. D3065
DATE	06.05.23			TITLE STEP LEG ASSEMBLY
				REV. B SHEET 4 OF 5 SCALE 1:3

RELEASED

06.05.20

**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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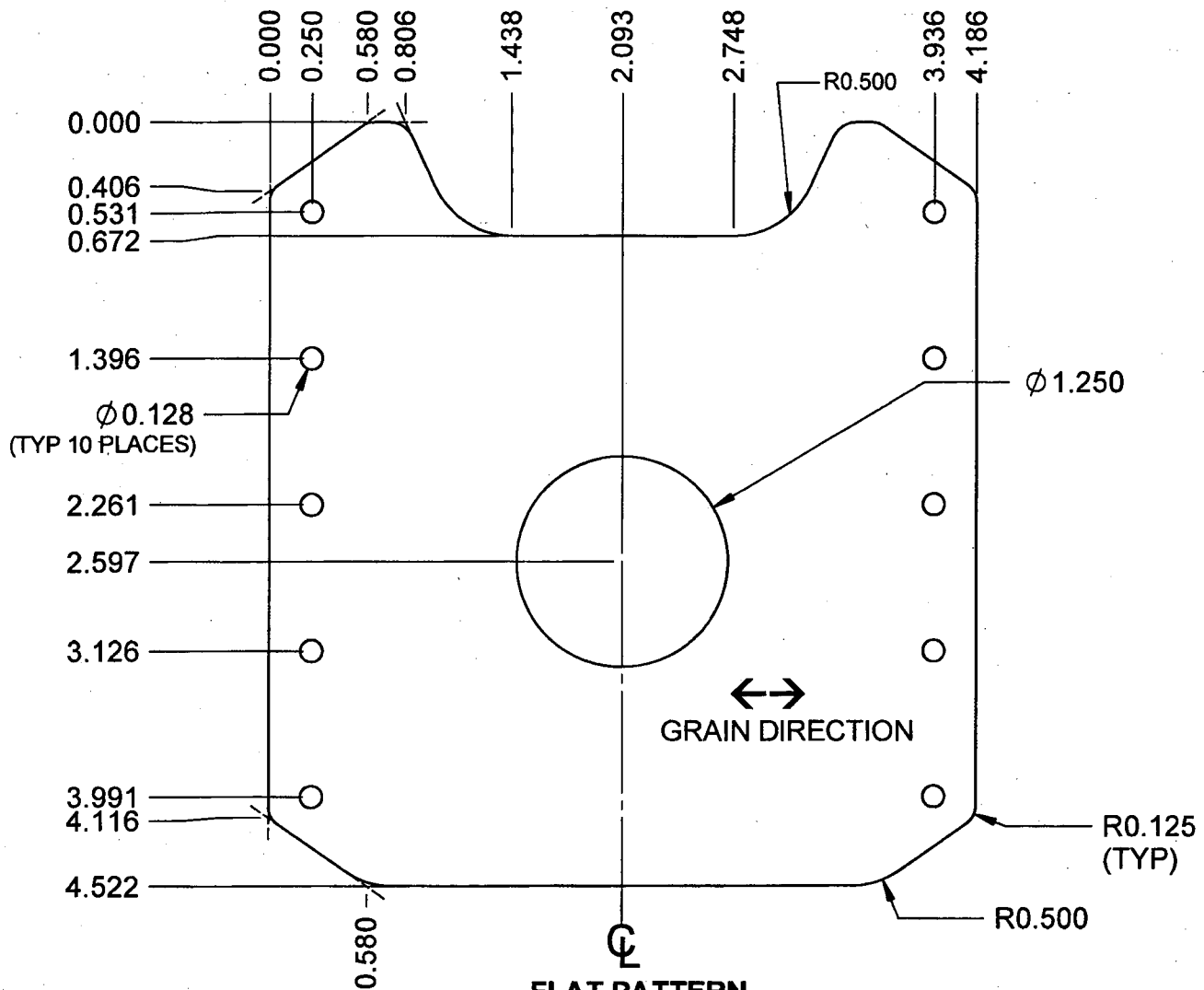
WORK ORDER
423718

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DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

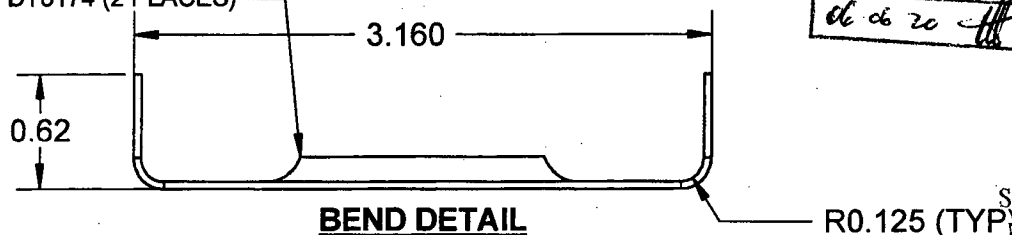


FLANGE AFTER BENDING TOWARDS
SIDE SHOWN USING DT8174 (2 PLACES)

FLAT PATTERN

RELEASED

06.06.20 *[Signature]*



BEND DETAIL

R0.125 (TYP)

D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3SI040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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